

Date: Tuesday, 10/2/2007 1:21:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 34956	
Estimate Number : 11167	
P.O. Number : <i>N/A</i>	Part Number : D32783
This Issue : 10/2/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 34525	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/30/2007 Qty: <i>100</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07.10.03	
Comment : Est. A 04.04.19 New issue KJ/JLM	
Est B 07.09.06 Rev C dwg EC Verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLINS0125	Black Delrin Sheet .125
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4:2237



Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.8060 sf(s)

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: *m15667**HB 07-10-3*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: *C*Prog Rev: *C*

2-Deburr if necessary

HB 07-10-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*HB 07-10-3*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

HB 07-10-3*counter*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:21:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 34956

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

with clean (no scratches) up

2-Deburr

07-10-01

07/10/30

(117)

(117)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QSP018

07/11/01

count

(117)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST. 84

(117)

07/11/02 AS

U

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(117)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

Job Completion



U 07.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34956
Description: Spacer		Part Number:	D3278-3
Inspection Dwg: D3278	Rev: <i>BC</i> 07.10.03 <i>DC</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.99	X			
1.98	+/-0.030	1.99	X			
1.480	+/-0.005	1.48	X			
0.250	+/-0.010	2.50	X			
1.480	+/-0.005	1.48	X			
0.250	+/-0.010	2.50	X			
Ø0.098	+0.005/-0.000	.100	X			
R0.12 R0.13	+/-0.030	.13	X			
0.125	+/-0.010	.125	X			

Measured by: <i>WB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 07-10-3	Date: 07/10/03	Date:	N/A

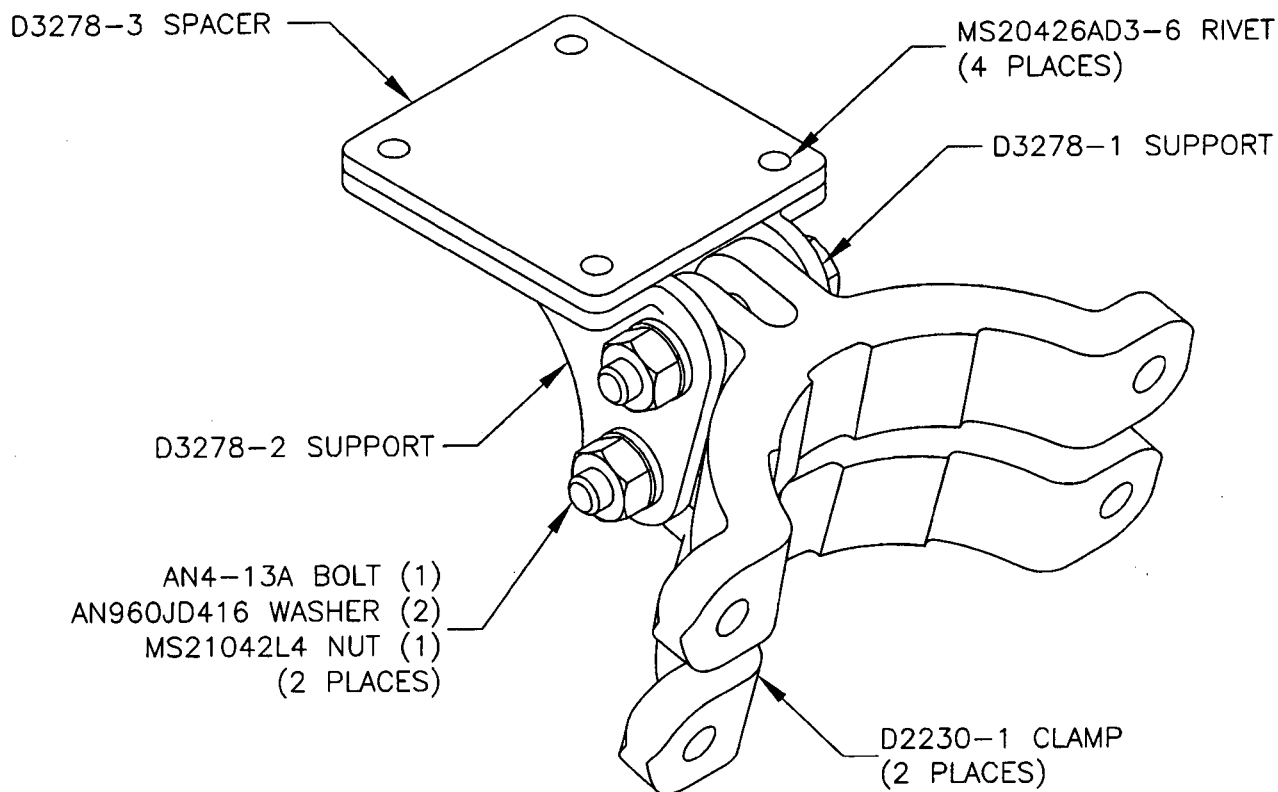
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM <i>JA</i>	<i>JA</i>



DESIGN 92	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-16

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

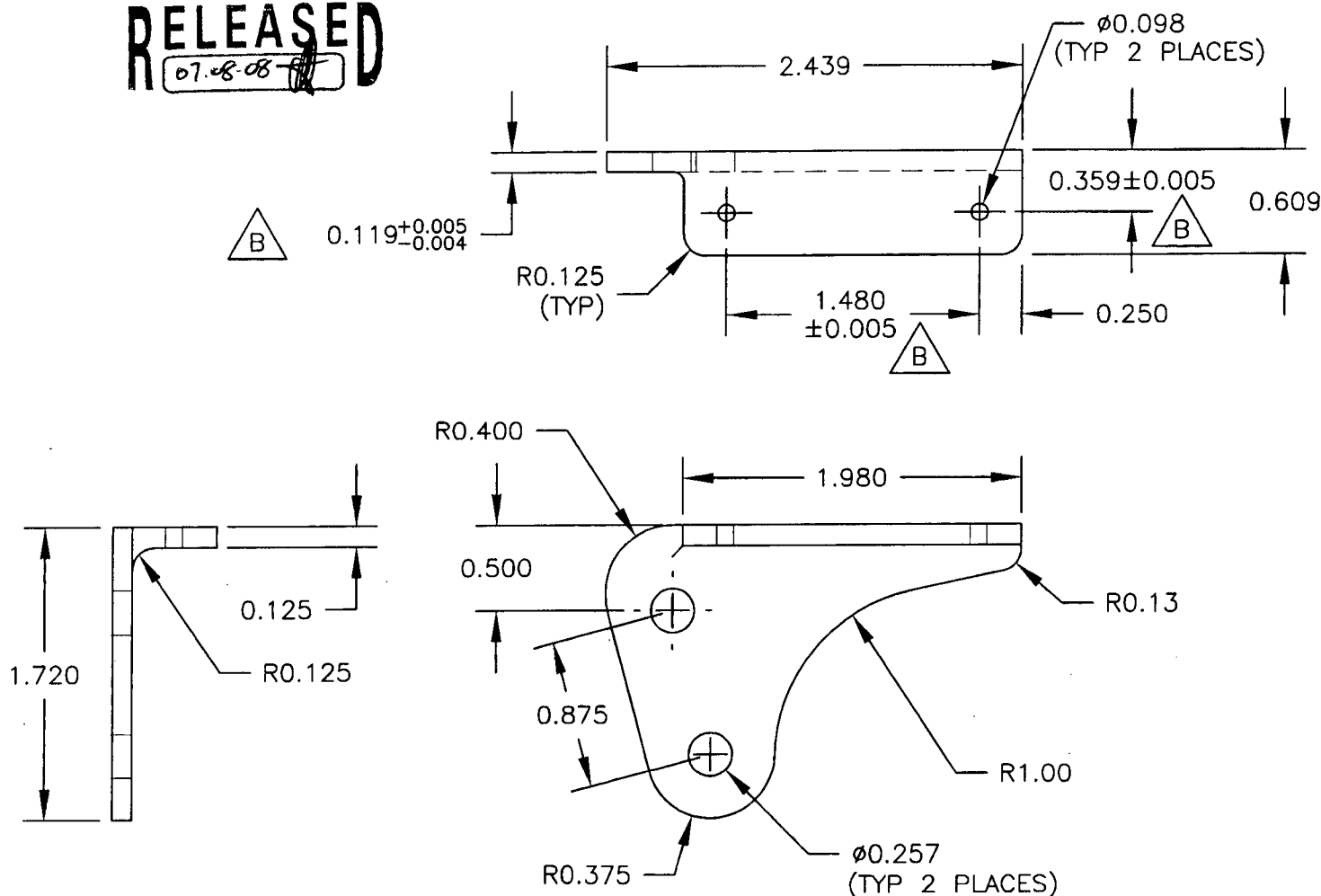
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

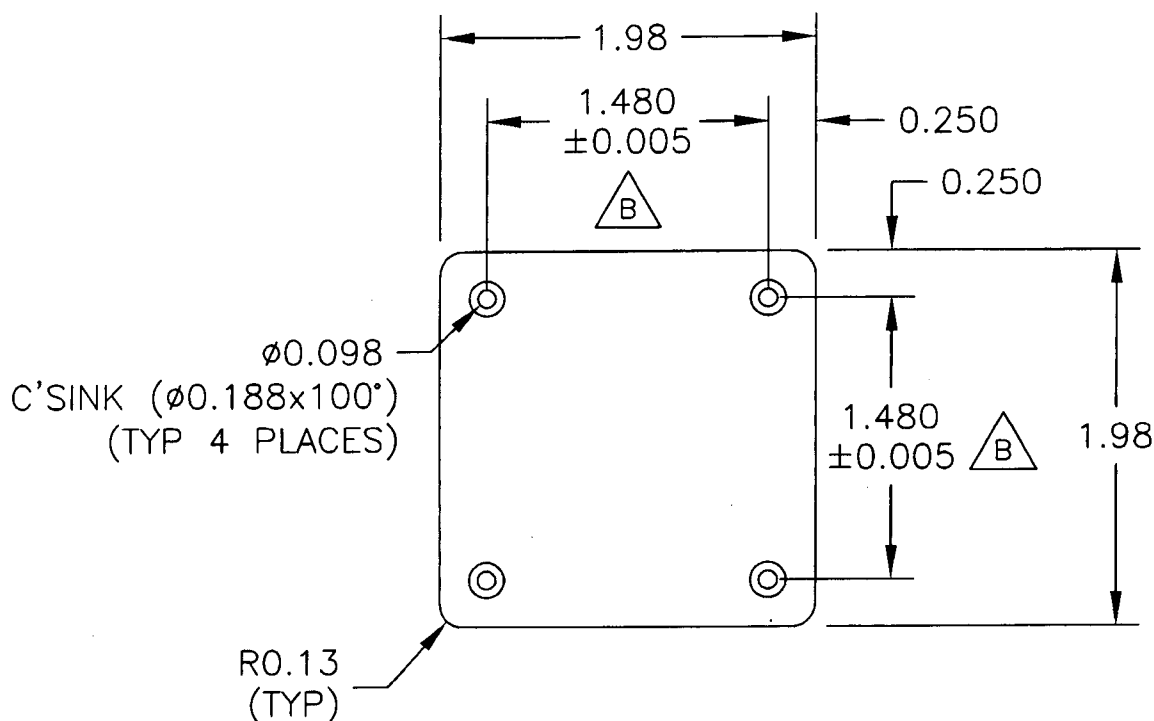
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DART

DESIGN 921	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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